

[Manuals.plus](#) /

› [TEENO](#) /

› TEENO DJ010 Thermofusion Kit Instruction Manual

TEENO DJ010

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Model: DJ010

1. INTRODUCTION

The TEENO DJ010 Thermofusion Kit is designed for efficiently joining PPR (Polypropylene Random Copolymer), PPB (Polypropylene Block Copolymer), and PPE (Polyethylene) pipes and fittings. This heat fusion method creates strong, leak-free connections essential for various plumbing and piping applications. This manual provides detailed instructions for safe operation, setup, maintenance, and troubleshooting to ensure optimal performance and longevity of your tool.

2. SAFETY INSTRUCTIONS

Always adhere to the following safety guidelines to prevent injury and damage to the equipment:

- Read and understand all instructions before operating the tool.
- Wear appropriate personal protective equipment (PPE), including heat-resistant gloves and eye protection.
- Ensure the work area is clean, well-lit, and free from flammable materials.
- Do not operate the tool in wet or damp conditions.
- Always disconnect the power supply before performing any maintenance, cleaning, or changing dies.
- Keep children and unauthorized personnel away from the work area.
- Do not touch the heating plate or dies when the tool is powered on or still hot.
- Use only original TEENO replacement parts and accessories.

3. PACKAGE CONTENTS

Verify that all items are present in your TEENO DJ010 Thermofusion Kit:

- 1 x TEENO DJ010 Thermofusion Machine (800W)
- 6 x Pairs of Thermofusion Dies (20mm, 25mm, 32mm, 40mm, 50mm, 63mm)
- 1 x Improved UT-Type Support Base
- 1 x Pipe Cutter (Scissors)
- 1 x Allen Key
- 6 x Screws
- 1 x Toolbox



Figure 3.1: Complete contents of the TEENO DJ010 Thermofusion Kit.

4. PRODUCT COMPONENTS

Familiarize yourself with the main components of the thermofusion machine:

DETALLES DE PRODUCTO



Figure 4.1: Labeled components of the TEENO DJ010 Thermofusion Machine.

- **Power Cable:** Connects the machine to the electrical supply.
- **Handle:** Ergonomic grip for safe handling.
- **Heat Shield:** Protects the user from direct contact with the heating element.
- **Anti-clogging Threading Head:** The main heating plate where dies are attached.
- **Widened Panel:** Provides a larger surface for heat distribution.
- **Improved UT Support:** Stable base for resting the machine during operation.
- **Vents:** For heat dissipation and cooling of internal components.

5. SETUP

Follow these steps to prepare your thermofusion kit for use:

1. **Attach the Support Base:** Secure the improved UT-type support base to the thermofusion machine using the provided screws and Allen key. Ensure it is stable.

BASE TIPO UT

Aumenta el efecto de soporte de peso, más estable.



Figure 5.1: Thermofusion machine with the UT-type support base attached.

2. **Select and Install Dies:** Choose the appropriate die size (male and female) that matches the diameter of the pipe and fitting you intend to fuse. Securely attach the dies to the heating plate using the screws and Allen key.

PARAMETROS DEL PRODUCTO



Φ32 (1")



Φ25 (3/4")



Φ20 (1/2")



Φ63 (2")



Φ50 (1 1/2")



Φ40 (1 1/4")

Figure 5.2: Available thermofusion die sizes.

3. **Connect to Power:** Plug the power cable into a suitable electrical outlet. The machine will begin to heat up. Allow approximately 5 minutes for the dies to reach the optimal fusion temperature.

6. OPERATING INSTRUCTIONS

Perform the thermofusion process carefully:

1. **Prepare Pipes and Fittings:** Ensure the pipe ends and fitting interiors are clean, dry, and free from debris. Use the included pipe cutter to make a straight, perpendicular cut on the pipe end.

TUBO DE FUSIÓN RÁPIDA



Figure 6.1: Using the pipe cutter for a clean, straight cut.

2. **Heat Pipes and Fittings:** Once the machine reaches the operating temperature, simultaneously insert the pipe end into the female die and the fitting onto the male die. Apply gentle, even pressure. Refer to the table below for typical fusion temperatures for different pipe materials.

ADECUADO PARA



PPR

Se utiliza comúnmente en tuberías de agua fría y caliente, con un punto de fusión de aproximadamente **260-280 ° C**.



PPB

Usado comúnmente para calentar tubos, el punto de fusión es de aproximadamente **240 ° C**.



PPE

Generalmente utilizado en sistemas de drenaje, el punto de fusión es de aproximadamente **200-230 ° C**.

Figure 6.2: Compatible pipe types and their fusion temperatures.

3. **Fusion Time:** Hold the pipe and fitting on the dies for the recommended heating time (typically a few seconds, depending on pipe diameter and material). The material should soften and show a slight bead around the edges.
4. **Join Components:** Immediately after heating, remove the pipe and fitting from the dies and quickly join them together with a firm, straight push. Do not twist.
5. **Cooling:** Hold the joined components firmly in place for a few seconds to allow the fusion to set. Let the joint cool completely before applying any stress or pressure.

7. MAINTENANCE

Proper maintenance ensures the longevity and efficiency of your thermofusion kit:

- **Cleaning Dies:** After each use, and once the dies have cooled, clean any plastic residue from their surfaces using a non-abrasive cloth. Do not use metal tools that could damage the Teflon coating.
- **Storage:** Store the thermofusion machine and all accessories in the provided toolbox in a dry, clean place, away from direct sunlight and extreme temperatures.
- **Cable Inspection:** Regularly inspect the power cable for any signs of damage, cuts, or fraying. If damage is found,

discontinue use and have it repaired by a qualified technician.

- **General Inspection:** Periodically check all screws and fasteners to ensure they are tight.

8. TROUBLESHOOTING

If you encounter issues, refer to the following common problems and solutions:

Problem	Possible Cause	Solution
Machine does not heat up.	No power supply; faulty power cable; internal malfunction.	Check power connection and outlet. Inspect power cable for damage. If problem persists, contact customer support.
Poor fusion quality (leaks, weak joints).	Insufficient heating time; incorrect temperature; improper pipe preparation; twisting during joining.	Ensure adequate heating time. Verify dies are clean. Ensure pipe ends are clean and cut straight. Join components quickly and without twisting.
Dies are difficult to clean.	Plastic residue has hardened; abrasive cleaning used.	Clean dies immediately after they cool. Use a non-abrasive cloth. Avoid scratching the Teflon coating.

9. SPECIFICATIONS

- **Model:** DJ010
- **Brand:** TEENO
- **Rated Power:** 800 Watts
- **Voltage:** 110-270V
- **Frequency:** 50/60Hz
- **Compatible Pipe Materials:** PPR, PPB, PPE
- **Die Sizes Included:** 20mm (1/2"), 25mm (3/4"), 32mm (1"), 40mm (1 1/4"), 50mm (1 1/2"), 63mm (2")
- **UPC:** 791541912012

10. WARRANTY AND SUPPORT

Your TEENO DJ010 Thermofusion Kit comes with a commitment to quality and customer satisfaction.

- **Warranty:** This product is covered by a **one-year post-sale guarantee** from the date of purchase. This warranty covers manufacturing defects under normal use. Please retain your proof of purchase for warranty claims.
- **Customer Support:** For technical assistance, warranty claims, or any questions regarding your TEENO DJ010 Thermofusion Kit, please contact TEENO customer service through your retailer or the official TEENO support channels.

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